

dup 20 Sept!

# Work Order ID 57265

Monday, September 13, 2010 8:44:56 AM



Page 1

Item ID: D3589-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Guide

Start Date: 3/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

Weld per dwg A/R S.S. rod Batch: M108160 0.00



Large Fab

Memo

0.00

1- assemble and weld as per dwg D3589 QSI004

Large Fab

A/R Stainless Steel rod batch: M108160

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*10-09-15*

*4*

*10.09.21*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*506021*

*(X4)*

*10-9-13 (X4)*

**Work Order ID 57265**

Monday, September 13, 2010 8:44:56 AM



Page 2

Item ID: D3589-049

Accept



Setup Start



Revision ID:

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Item Name: Aft Guide

Start Date: 3/31/2010 Start Qty: 4.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 65

0.00



Packaging

Memo

0.00

Packaging

10/9/21 SL (40)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/21 df

mf

10-9-21

# Picklist Print

Monday, September 13, 2010 8:44:56 AM

Page 1

Work Order ID: 57265

Parent Item: D3589-049

Parent Item Name: Aft Guide



Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-30 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-19  Aft Guide Plate		Manufactured	No			100	Each	14.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
					56916			14					
D3589-5  LATCH GUIDE		Manufactured	No			100	Each	12.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				12					
					56960			12					

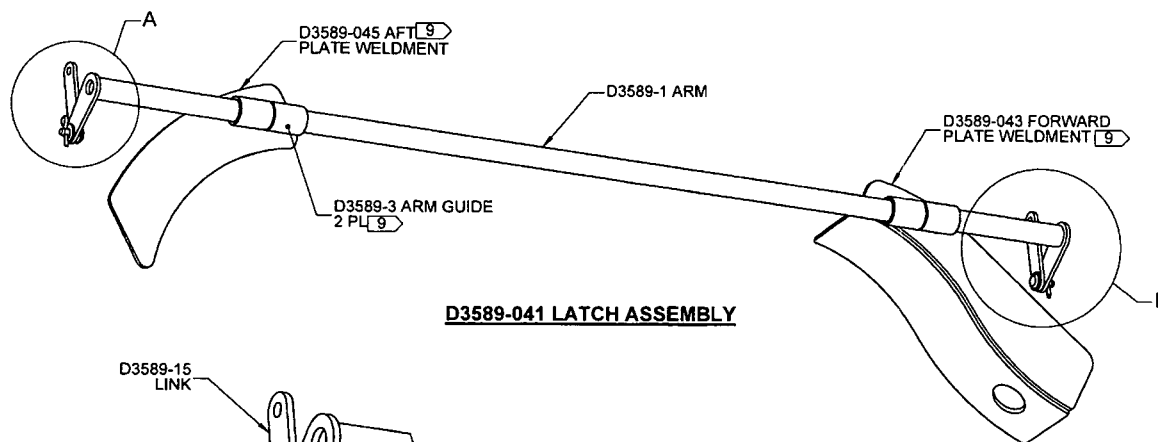
PL 10-9-13

4

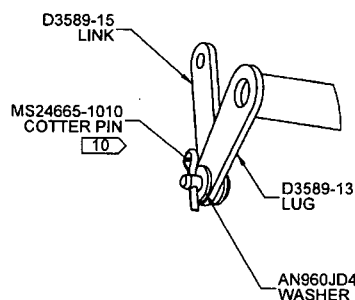
PL 10-9-13

4

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

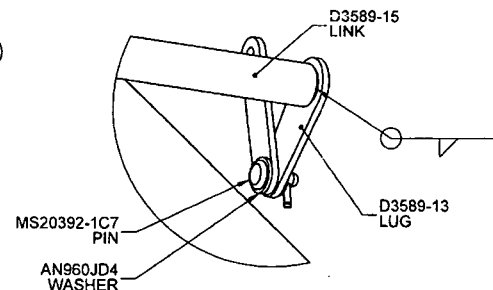


**D3589-041 LATCH ASSEMBLY**



**DETAIL A: LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL



**DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL**

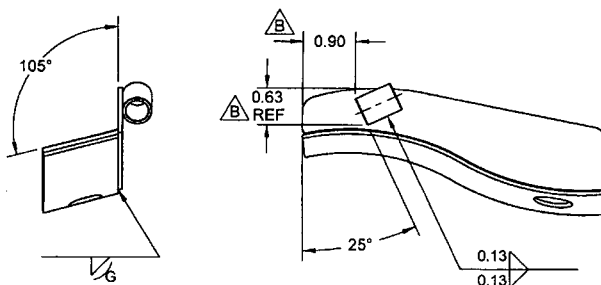
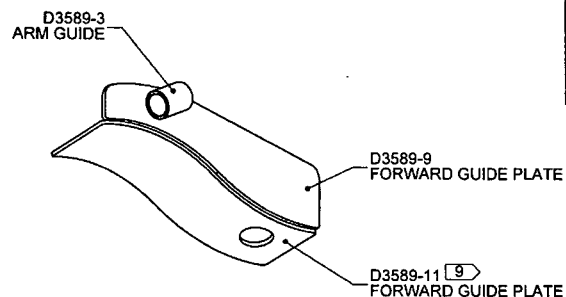
SCALE 2X  
2 PL

**D3589-041 NOTES:**

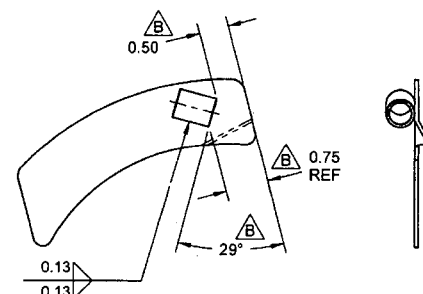
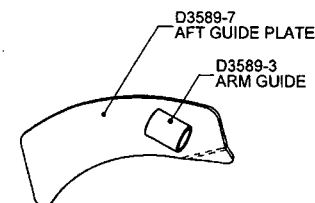
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.80 AND 0.83 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4) REDESIGNED D3589-8 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION		MB	08.06.25
A	NEW ISSUE		MB	08.05.29
REV.	DESCRIPTION		BY	DATE
DESIGN	JH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3589</b>  TITLE <b>LATCH ASSEMBLY</b>	REV. B	
DRAWN	JH		SHEET 1 OF 8	
CHECKED	PH		SCALE	
MFG. APPR.	DS		NT	
APPROVED	DS			
DE APPR.	JH			
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QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

**D3589-043/-045 NOTES:**

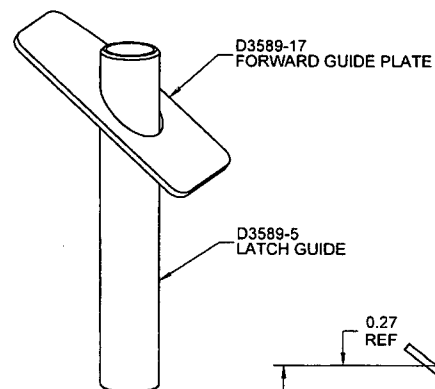
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
  - D3589-043 = 0.22 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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09/07/05 N/A

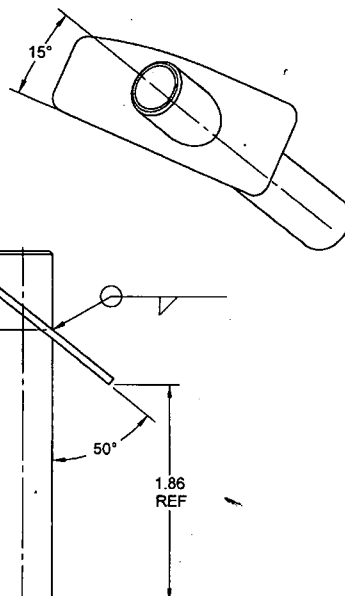
57265

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE

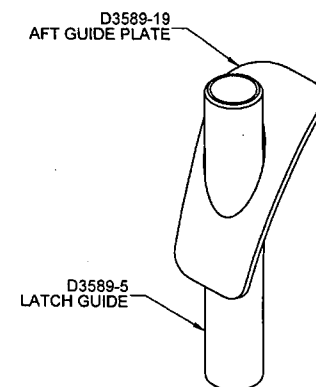


D3589-5  
LATCH GUIDE

D3589-17  
FORWARD GUIDE PLATE

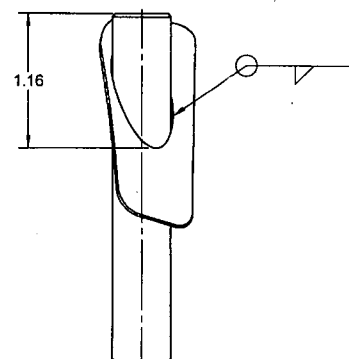


**D3589-047 FORWARD GUIDE**



D3589-5  
LATCH GUIDE

D3589-19  
AFT GUIDE PLATE



**D3589-049 AFT GUIDE**

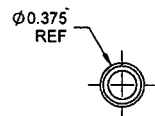
**D3589-047/-049 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

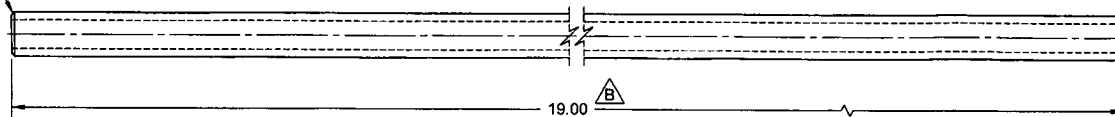
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DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D3589	SHEET 3 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LATCH ASSEMBLY	NTS
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9/10/25

52265

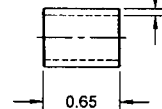
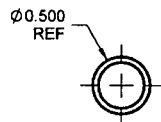


0.03 X 45°  
CHAMFER  
2 PL



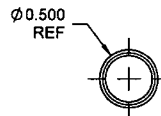
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REF

**D3589-1 ARM**

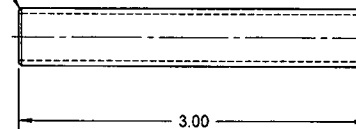


0.058  
REF

**D3589-3 ARM GUIDE**



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CHAMFER  
2 PL



0.049  
REF

**D3589-5 LATCH GUIDE**

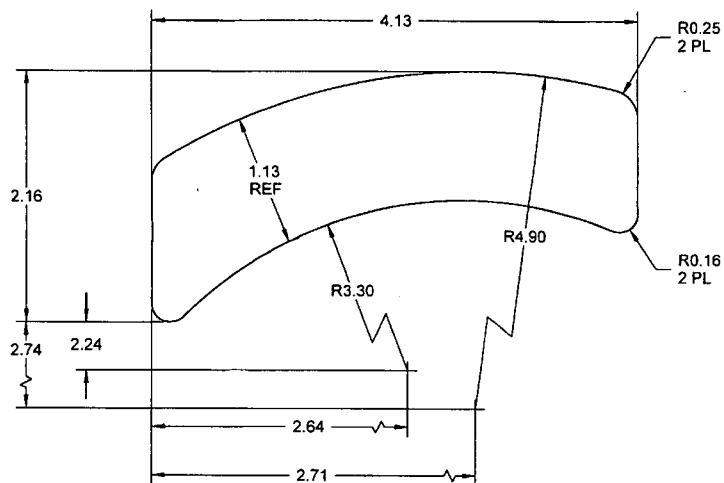
**D3589-1/-3/-5 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs  
- D3589-3 = 0.01 lbs  
- D3589-5 = 0.06 lbs

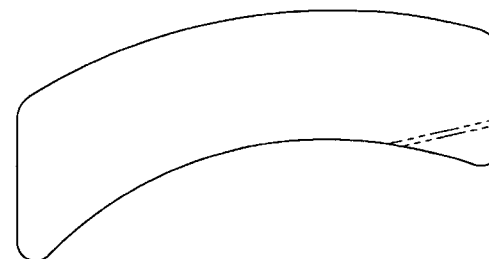
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09/02/25

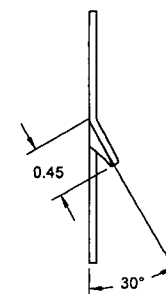
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DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D3589	SHEET 4 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LATCH ASSEMBLY	NTS
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**D3589-7F AFT GUIDE PLATE  
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE  
MAKE FROM D3589-7F**



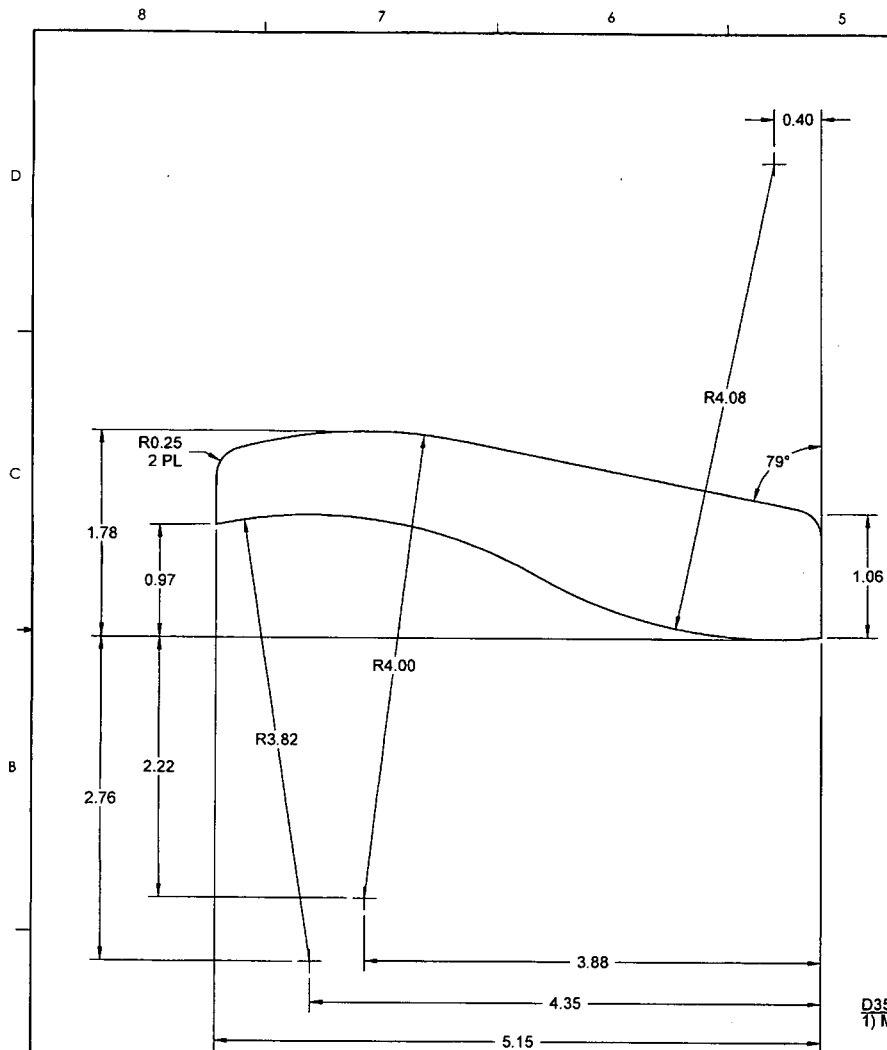
**RELEASED**  
09/24/05 NIP

**D3589-7F NOTES:**

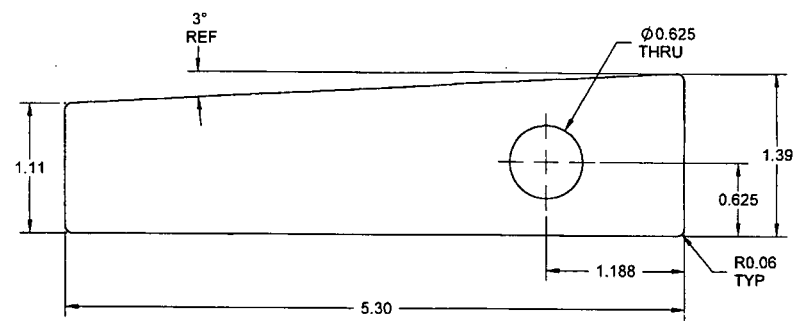
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

57265

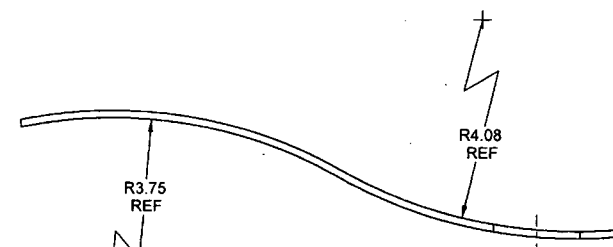
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DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3589	SHEET 5 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	11	LATCH ASSEMBLY	NTS
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**D3589-9 FORWARD GUIDE PLATE**



**D3589-11F FORWARD GUIDE PLATE**  
**FLAT PATTERN**

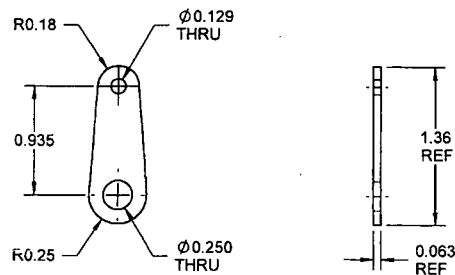


**D3589-11 FORWARD GUIDE PLATE**  
(MAKE FROM D3589-11F)

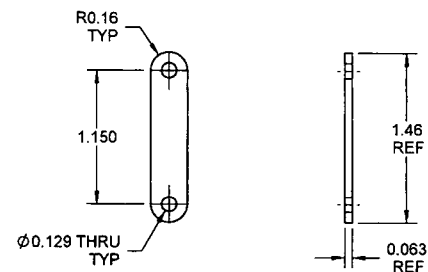
- D3589-9/-11/-11F NOTES:**  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,  
 PER AMS 5513 OR AMS 5524,  
 OR MIL-S-5059 (ANNEALED) 2B FINISH  
 16 GAUGE (0.063 THICK)  
 (REF. DART SPEC M304S16GA)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS  
 OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.09 lbs EACH  
 8) CONTROL SHAPE PER DT9021 TEMPLATE

**RELEASED**  
09/20/05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3589</b>	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>FORWARD GUIDE PLATE</b>	NTS
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**D3589-13 LUG**



**D3589-15 LINK**

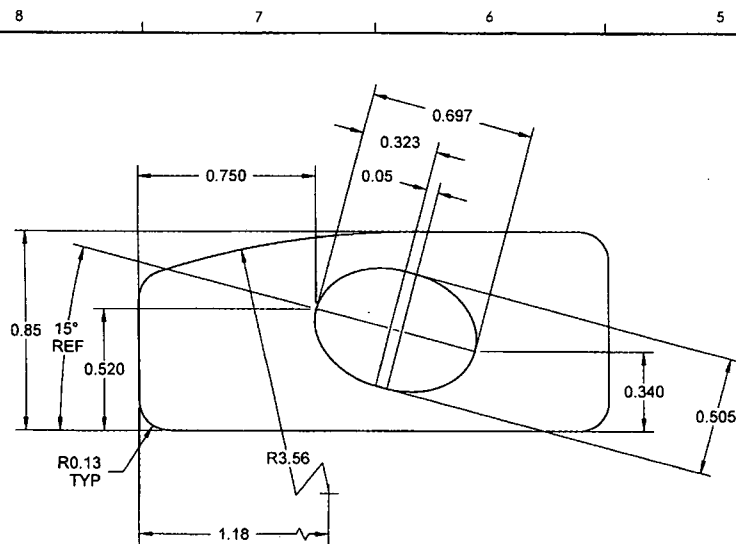
**D3589-13/-15 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

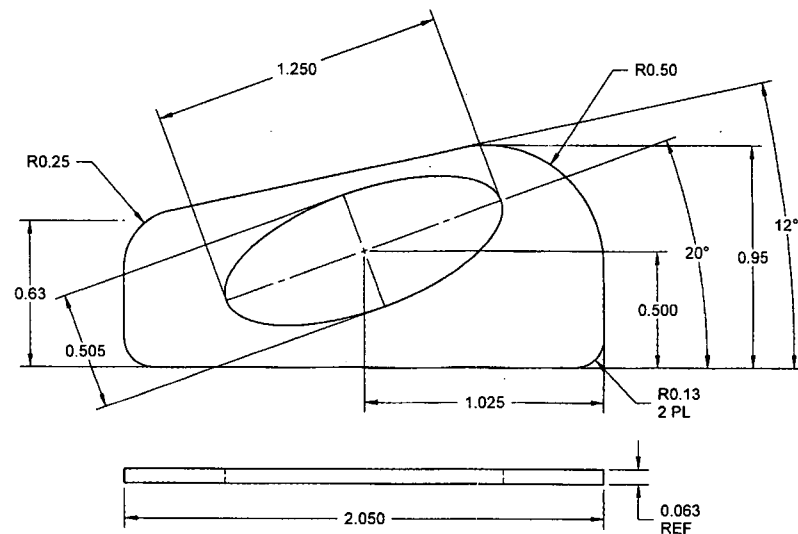
57265

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09/02/05

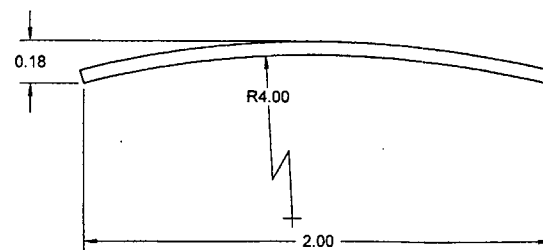
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 7 OF 8
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DE APPR.		LATCH ASSEMBLY	NTS
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**D3589-17 FORWARD GUIDE PLATE**



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE**  
(MAKE FROM D3589-19F)

**RELEASED**  
09/02/05/14

**D3589-17/-19/-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

57265

DESIGN	<i>JA</i>	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JA</i>	D3589	SHEET 8 OF 8
APPROVED	<i>JA</i>	TITLE	SCALE
DE APPR.	<i>JA</i>	LATCH ASSEMBLY	NTS
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